Each

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Dart Aerospace Lto Monday, 25/08/2008 9:56:00 AM **Process Sheet** : CU-DAR001 Dart Helicopters Services : LUG **Drawing Name** Job Number : 41610 Estimate Number : 10008 P.O. Number : D2591 **Part Number** This Issue : 25/08/2008 S.O. No. : **Drawing Number** D2591 REV D Prsht Rev. : NC : N/A **Project Number** First Issue : // Туре : MACHINED PARTS : D **Drawing Revision** : 39864 Previous Run Material : 10/09/2008 **Due Date** Qty: Written By Checked & Approved By Comment Removed from 9 Digit 05-10-25 JLM\ Est Rev:J Now Sub-Contracted 08-06-13 JLM Verified By:EC **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 M1010B0500X03000 1010-1025 BAR.500"x3.00" 0.2340 f(s)/Unit Total: Comment: Qty.: 9.3600 f(s) ASTM A36 Steel bar 3.00" X .500" thick Batch: M./0X336 2.0 BAND SAW BAND SAW Comment: BAND SAW Cut blanks: 2.500" long 3.0 PG PURCHASING Comment: |ssue P/O: 7025 C208/08/26 Make as per Dwg D2591 Possible Supplier:Metec PACKAGING 1 4.0 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage

5.0 QC6



Comment: DIMENSIONAL CHECK





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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE STEP Part No:		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition		QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAL	NCE (NC	R)			
		Description of NC	Corrective Action			Verifi	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		& Sect		Chief Eng	QC Inspector
<u> </u>									
		,	Section A Initial Action Description Sign & Section C						

NOTE: Date & initial all entries

Date: Monday, 25/08/2008 9:56:00 AM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 41610

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1



YOX

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

499

SU

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/10 4

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-0

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGI	ES				*** * * * * * * * * * * * * * * * * * *
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng /	Approval QC Inspector
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK ORE	ER NON-CONFORMA	NCE (NCF	R)			
2475		Description of NC		on B	Verifi	erification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Sec	tion C	Chief Eng	QC Inspector
Í									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: L	116100
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

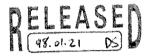
	FIRS	T ARTICLE IN	NSPECT	ON CHE	ECKLIST		
	x	First Arti	cle	Prot	otype	_	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.20	+/-0.030						
Ø0.510	+/-0.010						
0.125	+/-0.010		-				
2.44	+/-0.030						
0.65	+/-0.030			/	1		
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easured by:		Audited by:			Prototype App	proval:	N/A
Date:		Date:				Date:	N/A
ev Date	Change				l Ba	vised by	Approve

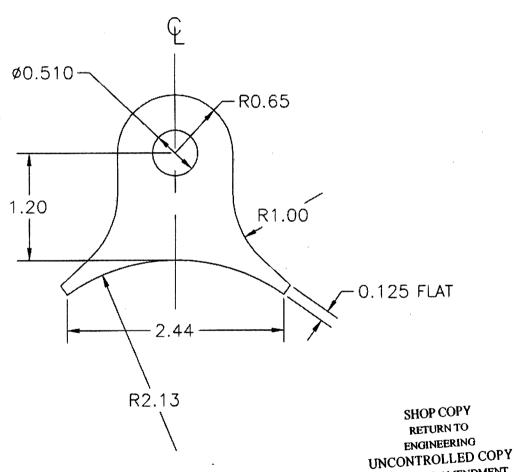
Rev	Date	Change		Revised by	Approx/ed
Α	04.08.12	New Issue	P/O D205-641-011 & DSI 9161-011	KJ/JLM ox	
				777	





	DESIGN		DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA					
١.	CHECK	(ED	APPROVED	DRAWING NO.	REV. D				
		LE	800	D2591 SHEET	1 OF 1				
	DATE			TITLE	SCALE				
	98.0	1.21		GHW LUG	1:1				
	Α		96:09:16	NEW ISSUE					
	В		97:06:17	RE-DESIGN TO FLAT BOTTOM					
	С		97.12.12	RE-DESIGN TO RADIUS BOTTOM					
	0		98 01 21	0 125 FLAT WAS 0.067 FLAT					





SUBJECT TO AMENDMENT WITHOUT NOTICE WORK/ORPER

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.063

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES



CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40

D2591

Lug B41610

7025

MATERIAL: supplied by DART M1010B0500X03000M108336

04/07/07

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, September 5, 2008